

## Work Order ID 60248



Page 1

Tuesday, June 29, 2010 3:48:20 PM

Item ID: D3813-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Assembly, Upper Door

Start Date: 6/29/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *6/29*

Tooling:

Date:

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3813	Rev A								

100



Small Fab

0.00

*(QA)*

Small Fab

Memo

0.00

Small Fab

1-Install helicoils as per Dwg D3813 2-Install Ball joint and nut loosely as per Dwg D3813

*=> M-f W/07/13*

110



QC5- Inspect part completeness to step on W/O

0.00

*S 060714*
*(7)*

Quality Control

120

Identify as per dwg & Stock Location: *089*

0.00

*L 07/14 (2)*

Packaging

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 60248**

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Item ID: D3813-041

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Item Name: Hinge Assembly, Upper Door

Start Date: 6/29/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan

Accept

Reject

Reject

Insp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

JULY 15

MF  
10-7-14

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# Picklist Print

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Tuesday, June 29, 2010 3:48:23 PM

Work Order ID: 60248



Parent Item: D3813-041



Parent Item Name: Hinge Assembly, Upper Door

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3518-3		Manufactured	No			100	Each	14.0000	1	2			

Stainless Steel Ball Joint Rod End

Location	Loc Qty	Loc Code
ST067	14	
39029	6	
53454 ✓	8	

D3813-1



Hinge, Upper Door

Location	Loc Qty	Loc Code
ST090	10	
52288 ✓	10	

MS124738



Heli-Coil 3/8-24 unf

Location	Loc Qty	Loc Code
ST314	45	
113368 ✓	45	

NAS509-6



Nut

Location	Loc Qty	Loc Code
ST280	20	
113537 ✓	20	

2x m-l 10/07/08

2x m-l 10/07/08

2x m-l 10/07/08

2x m-l 10/07/08

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

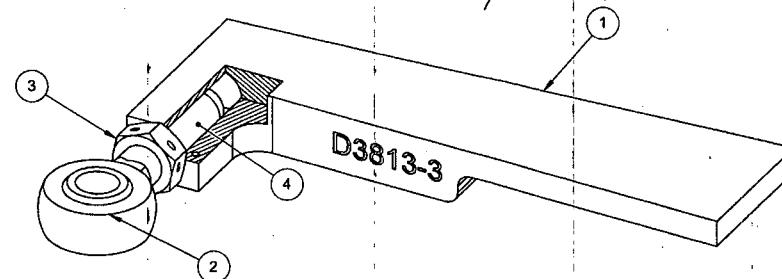
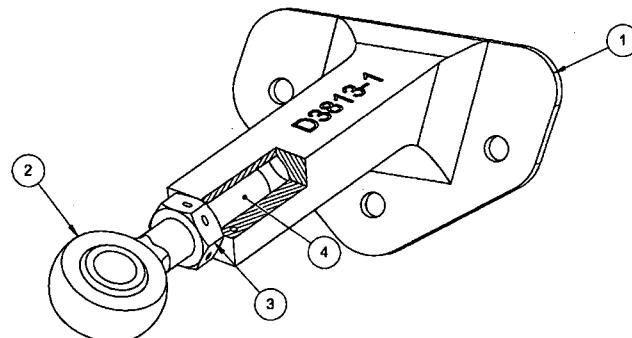
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STRUCTURE

RETURN TO

ENGINEERING  
UNCONTROLLED CO  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. *C02298**3810-G-29*

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3813-1	HINGE, UPPER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-041 HINGE ASSY, UPPER DOOR

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -043
1	D3813-3	HINGE, LOWER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-043 HINGE ASSY, LOWER DOORRELEASED  
*09/07/13 AM*

A	NEW ISSUE	REV.	08.11.10
DESCRIPTION		BY	DATE
DESIGN	<i>E</i>	DART AEROSPACE LTD	
DRAWN	<i>E</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>E</i>	DRAWING NO. REV. A	
MFG. APPR.	<i>E</i>	D3813 SHEET 1 OF 4	
APPROVED	<i>E</i>	TITLE	SCALE
DE APPR.	<i>E</i>	HINGE	NTS
DATE	08.11.10		

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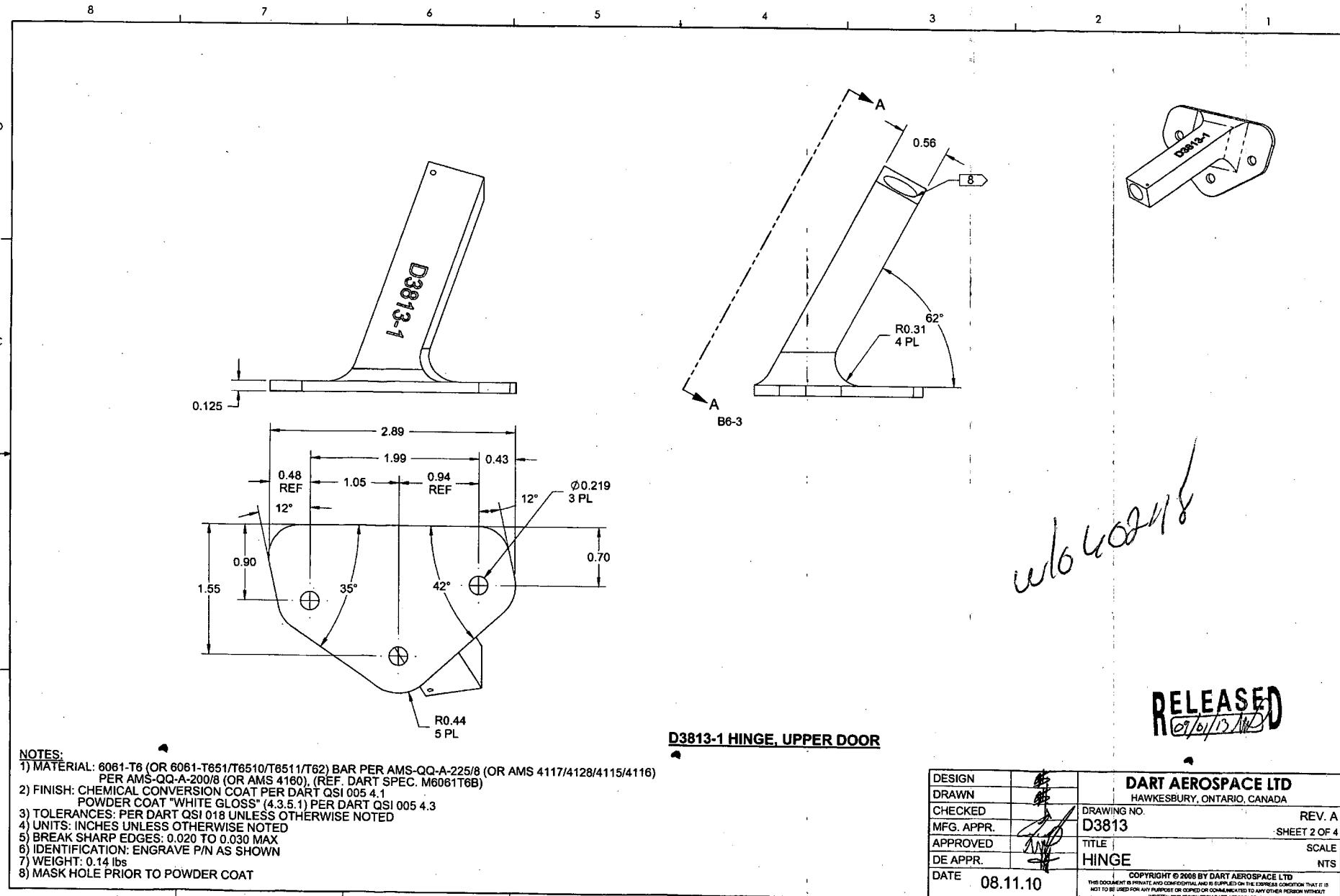
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CHECKED	<i>[Signature]</i>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE
DE APPR.	<i>[Signature]</i>	SCALE
DATE	08.11.10	NTS

**D3813**

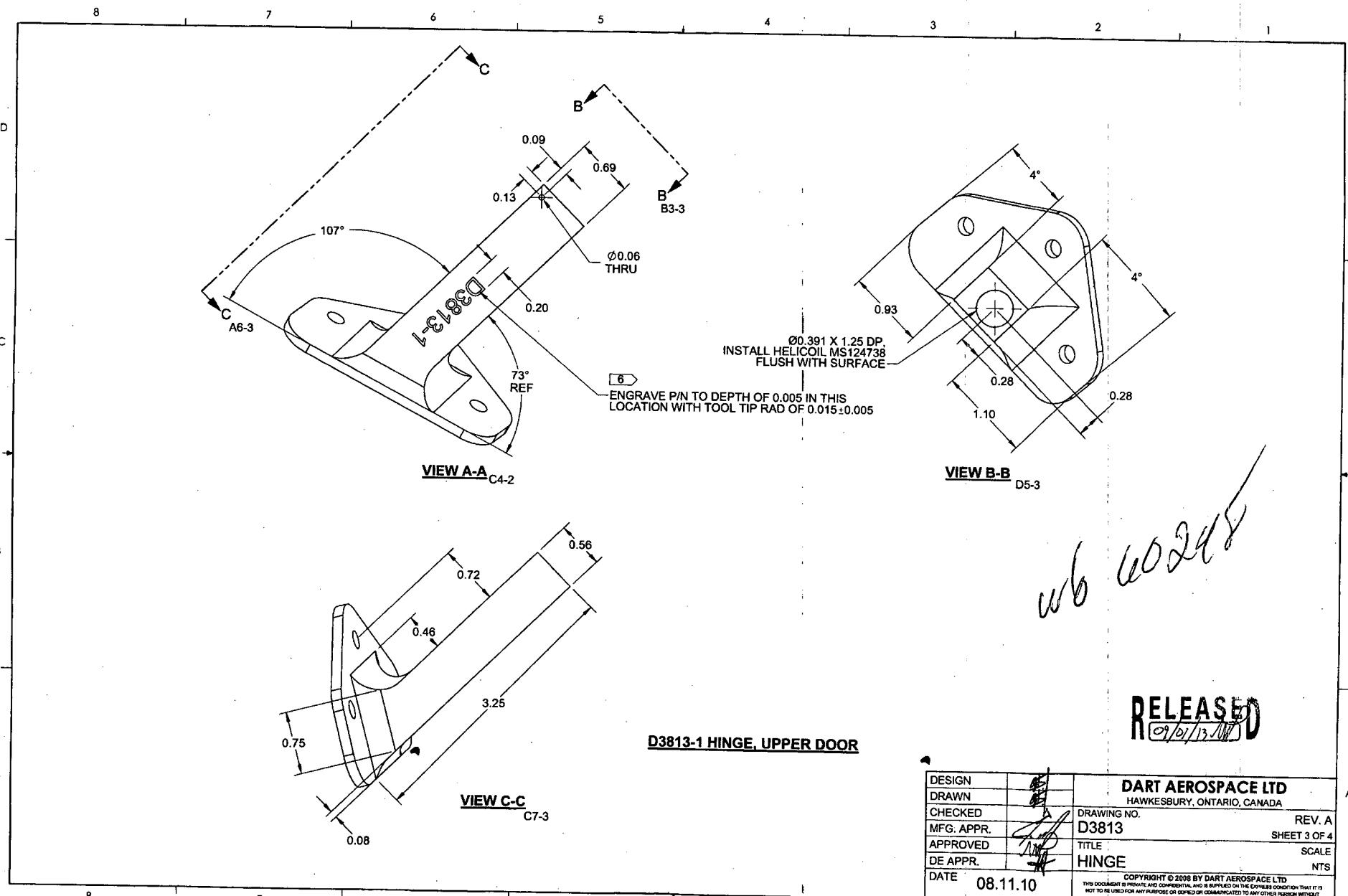
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CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D3813
APPROVED	<i>[Signature]</i>	REV. A
DE APPR.	<i>[Signature]</i>	SHEET 3 OF 4
DATE	08.11.10	SCALE NTS

**RELEASED** *[Signature]* 09/01/13

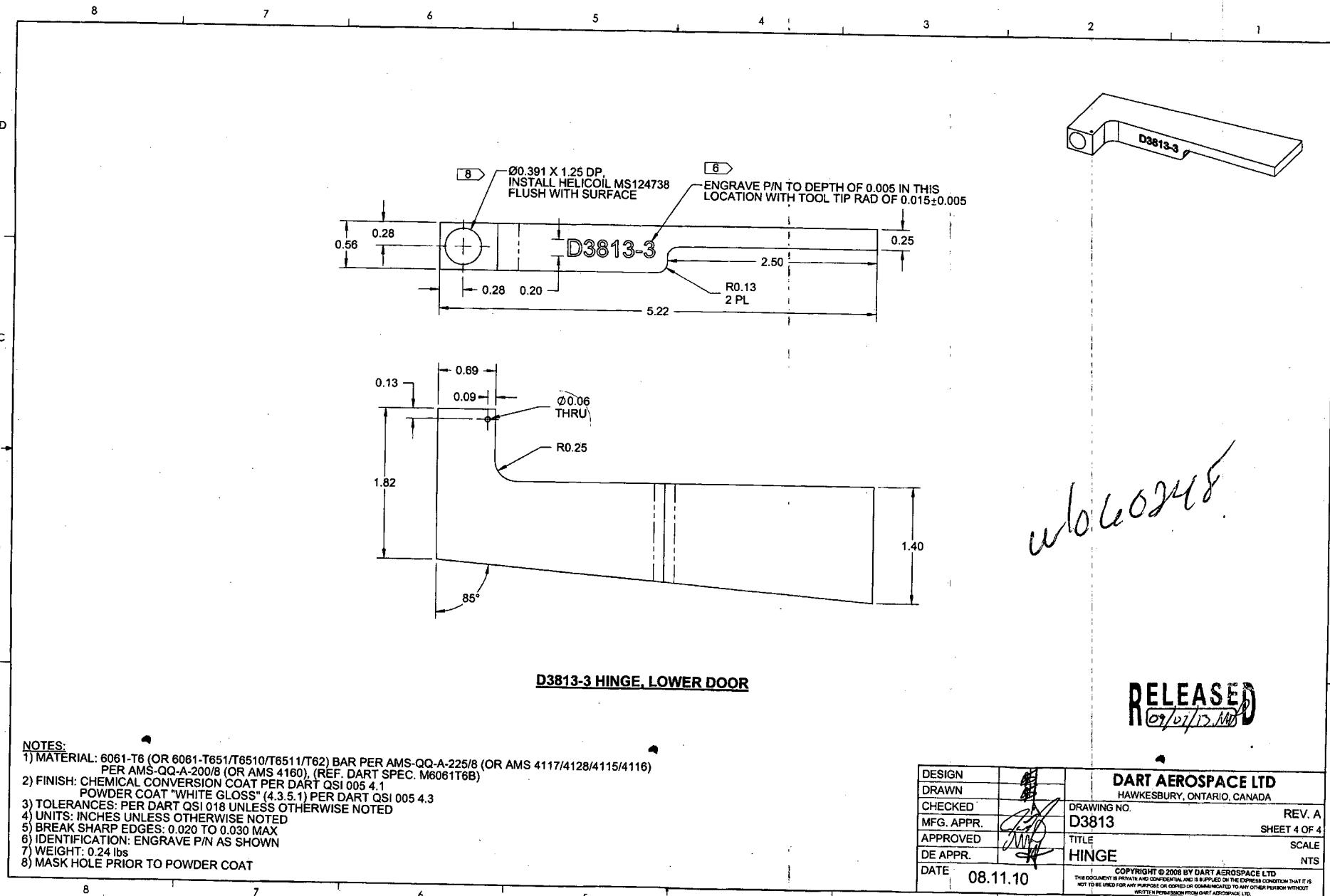
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